

Tuesday, August 23, 2016 8:12:57 AM

Page 1

NS1

NS?

Reference:

NR1

NR2

120	QC2- Inspect parts off machine FAI/FAIB	0.00	
120			DAS 08 9-85
QC	Memo	0.02	D.A. 16/09/06 14 φ
Quality Control			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

Tuesday, August 23, 2016 8:12:57 AM

Page 2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 150040

Tuesday, August 23, 2016 8:12:57 AM

150040

Page 3

Item ID: D3674-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Roller Bracket Assembly
Start Date: 8/24/2016 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 9/2/2016 Req'd Qty: 14.00 ***14*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>Stoso</u>	0.00				<u>14</u>			
160									
Packaging	Memo	0.02							
Packaging							DAS 6 9-89		SEP 13 2016
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.23					DAS 21 9-89		SEP 13 2016
Quality Control									

DAS
21
9-89 SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER :			
Misidentified ☐		Past Due ☐					

Picklist Print

Tuesday, August 23, 2016 8:12:57 AM

Page 1

Work Order ID: 150040

150040

Parent Item: D3674-045

D3674-045

Parent Item Name: Roller Bracket Assembly

Start Date: 8/24/2016

Required Date: 9/2/2016

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP rev: A RQ Verified by: DD 16.06.24

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3137-5		Manufactured	No				Each	17.0000		14			
D3137-5									**			16/09/13	DAS 36 9-89
Washer													

Location	Loc Qty	Loc Code
ST019	17	
147380	17	

D3674-7		Manufactured	No				Each	0.0000		14			
D3674-7									**			16/09/13	DAS 36 9-89
Guide													

M174B0.500X02.000		Purchased	No			100	f	1.5500	0.375	5.526316			
M174B0.500X02.000									**			16/09/13	DAS 20 9-89
17-4 SS Bar .500 x 2.00													

Location	Loc Qty	Loc Code
MAT010	1.55	
m128572	1.55	

MS24694-S100		Purchased	No				Each	36.0000		14			
MS24694-S100									**			16/09/13	DAS 36 9-89
Flat Head Screw													

Location	Loc Qty	Loc Code
ST283	36	
m134574	36	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

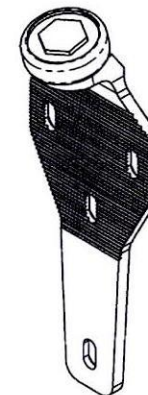
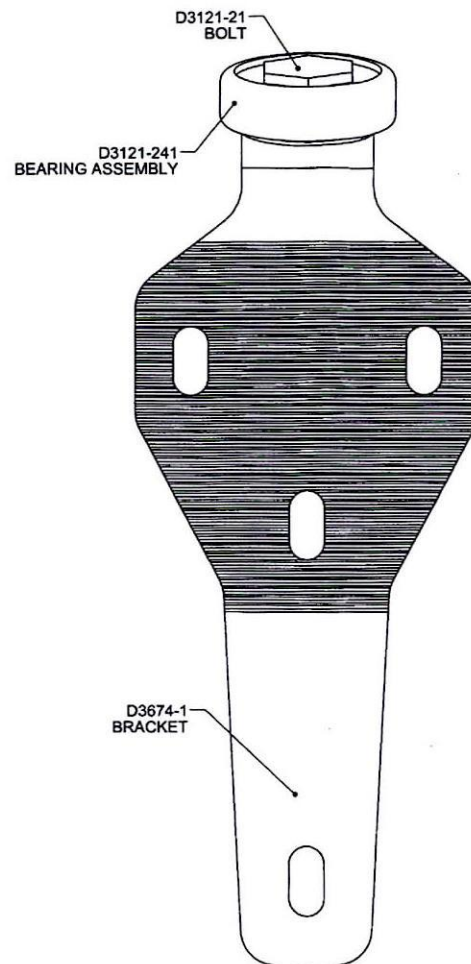
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3674-041	ROLLER BRACKET ASSEMBLY
1	1	D3674-1	BRACKET
2	1	D3121-21	BOLT
3	1	D3121-241	BEARING ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150046

2m 16/08/23

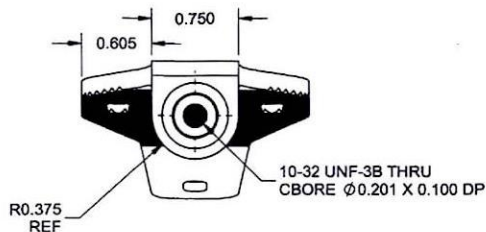
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs
8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

D3674-041 ROLLER BRACKET ASSEMBLY

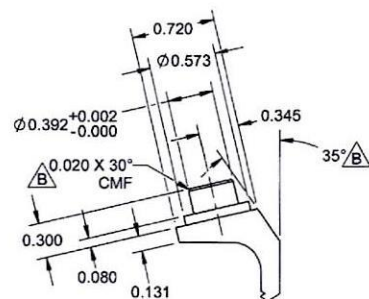
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2016-07-26
EN 16-531

APPROVED

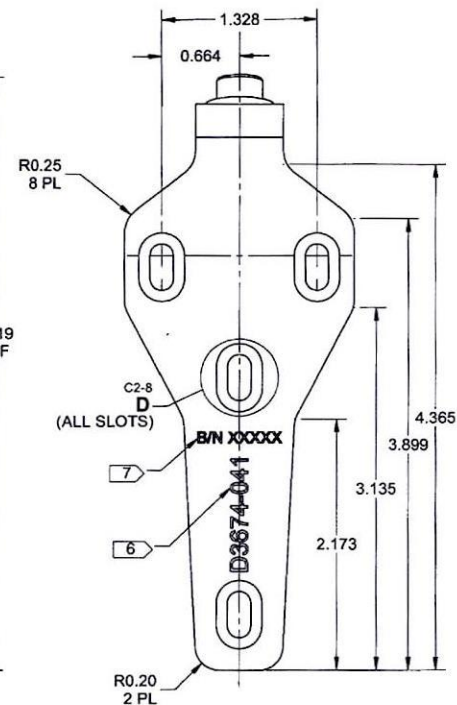
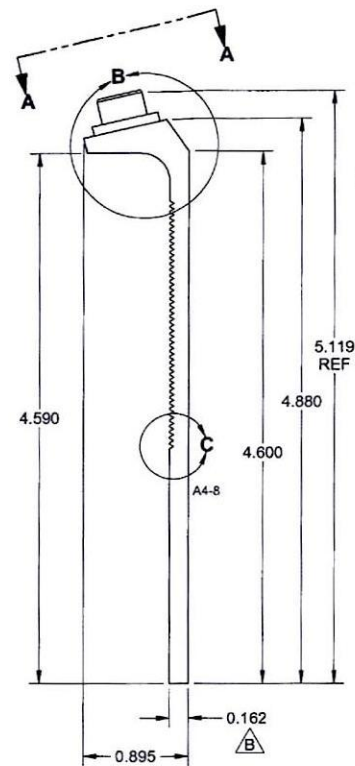
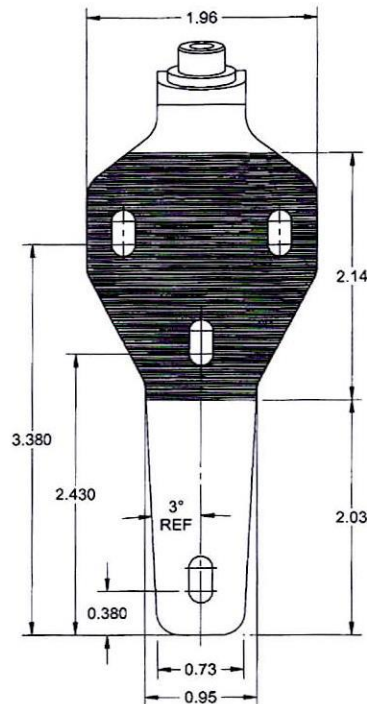
B	GENERAL UPDATE TO CURRENT STANDARDS. ADD -31-51-71-91-0431-0441-0451 FOR BELL COMPOSITE DOOR. B3-2 DIM 0.162 WAS 0.130. B7-2 35" WAS 30". SHT 2 UPDATE NOTE 6. SEE PAR 16-501.		AJS	16.06.01
A	NEW ISSUE		AJS	08.03.26
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	MB	DRAWING NO. D3674		
MFG. APPR.	RQ	REV. B SHEET 1 OF 8		
APPROVED	WM	TITLE ROLLER BRACKET ASSEMBLY		
DE APPR.	DS	SCALE NTS		
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



VIEW A-A



DETAIL B



D3674-1 BRACKET

NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-041" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.27 lbs
- 9) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.
- 10) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-1RevB.STP/SLDPRT"

RELEASED
2016-07-26

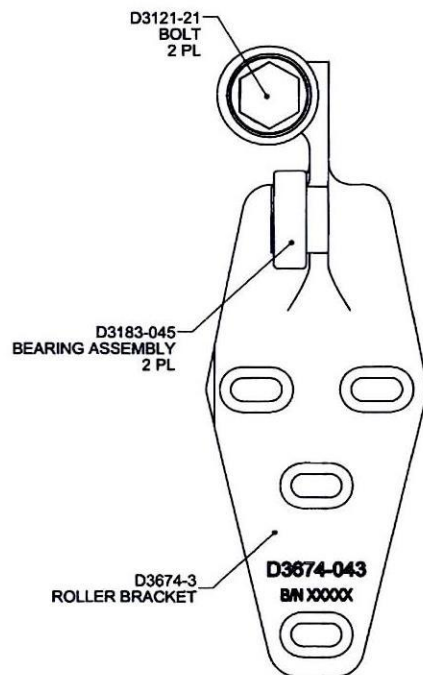
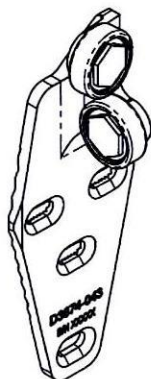
APPROVED

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DRAWN	AJS
CHECKED	MB
MFG. APPR.	RQ
APPROVED	WM
DE APPR.	DS
DATE	16.06.01

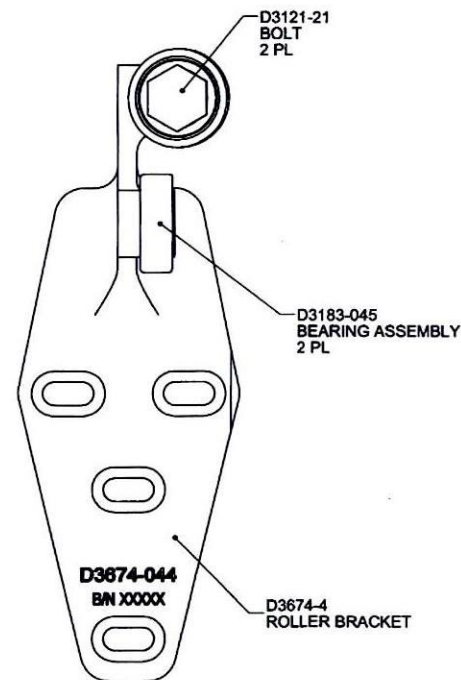
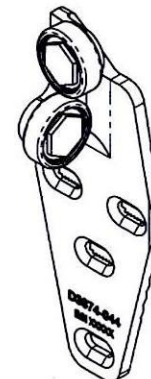
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3674	REV. B SHEET 2 OF 8
TITLE ROLLER BRACKET ASSEMBLY	SCALE NTS
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3674-043	ROLLER BRACKET ASSEMBLY
1	1	D3674-3	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3674-044	ROLLER BRACKET ASSEMBLY
1	1	D3674-4	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT



D3674-043 ROLLER BRACKET ASSEMBLY



D3674-044 ROLLER BRACKET ASSEMBLY

NOTES:

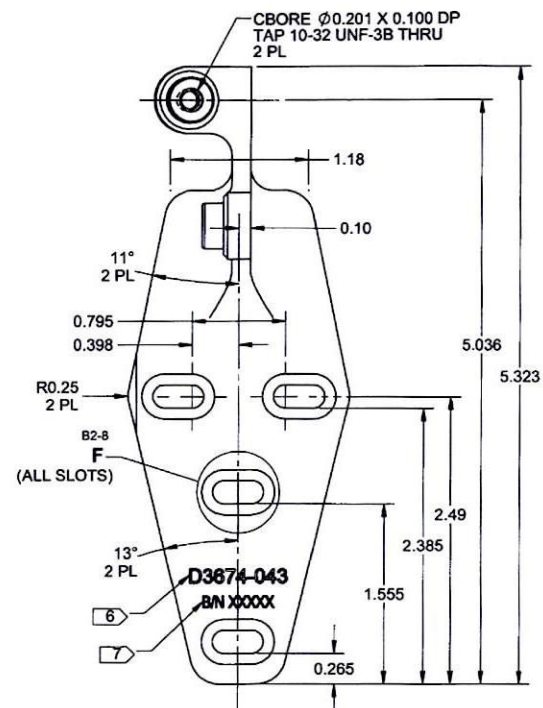
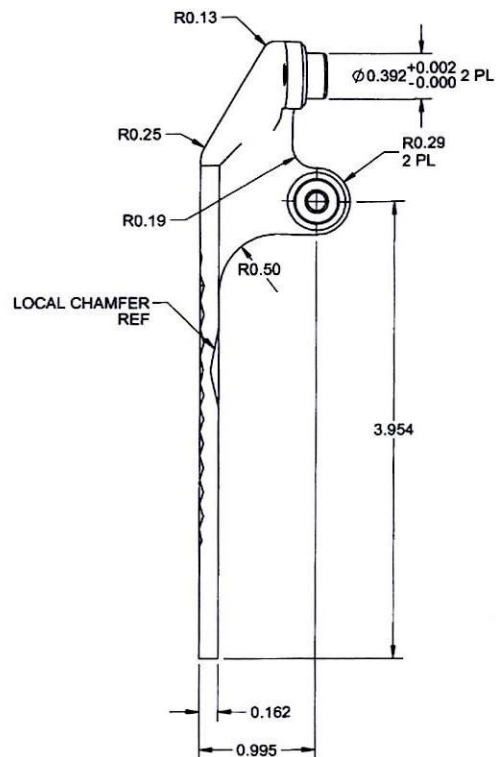
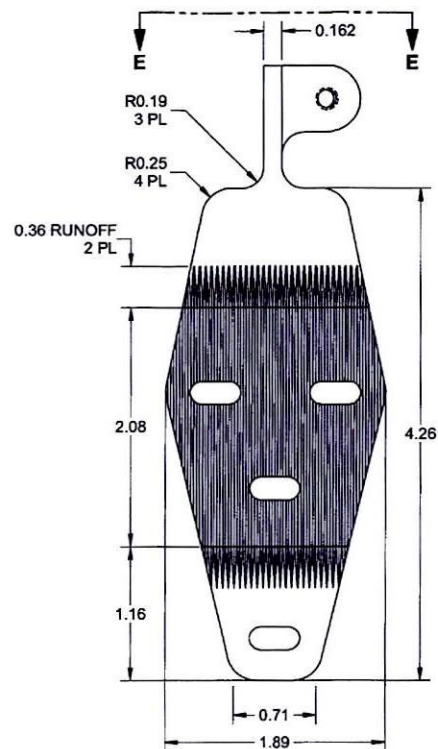
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 3 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2016-07-26

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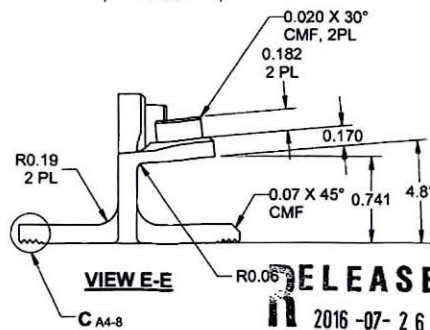
8 7 6 5 4 3 2 1



D3674-3 ROLLER BRACKET

NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-043" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.31 lbs
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-3RevB.STP/SLDPRT"

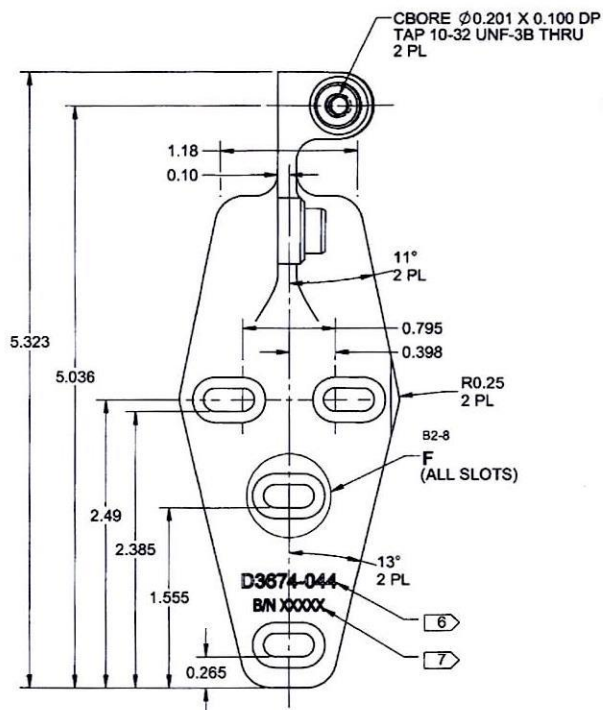


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2016-07-26

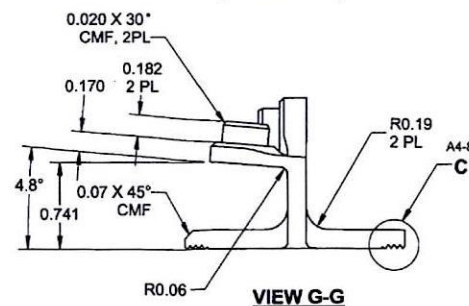
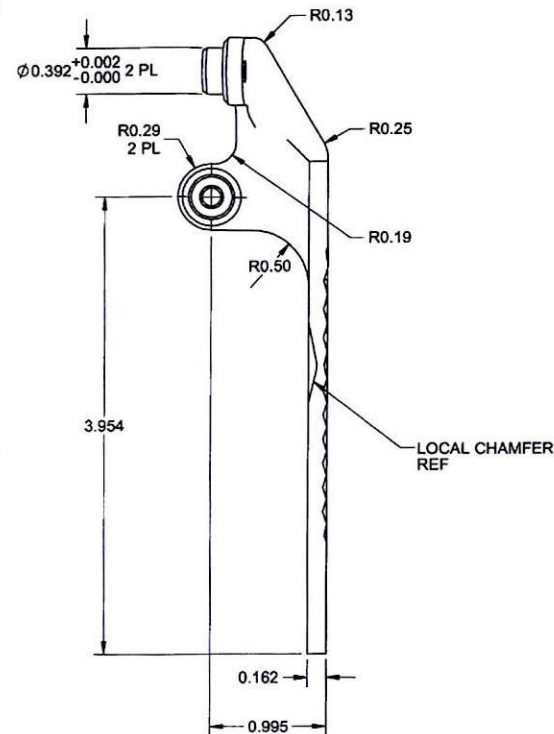
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 4 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	D9	ROLLER BRACKET ASSEMBLY	NTS
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

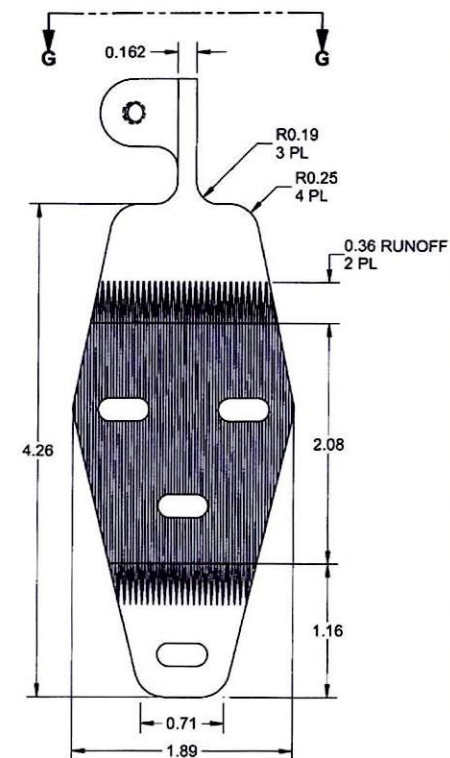
8 7 6 5 4 3 2 1



D3674-4 ROLLER BRACKET



VIEW G-G



- NOTES:**
- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-044" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
 - 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
 - 8) WEIGHT: 0.31 lbs
 - 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-4RevB.STP/SLDPRT"

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2016-07-26

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 5 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3674-045	ROLLER BRACKET ASSEMBLY
1	1	D3674-5	ROLLER BRACKET
2	1	D3674-7	GUIDE
3	1	D3137-5	WASHER
4	1	MS24694-S100	SCREW, CSK 100*

D3674-5
ROLLER BRACKET

D3674-7
GUIDE
D3137-5
WASHER

MS24694-S100
SCREW, CSK 100*

D3674-045
B/N XXXXX

D3674-045 ROLLER BRACKET ASSEMBLY 

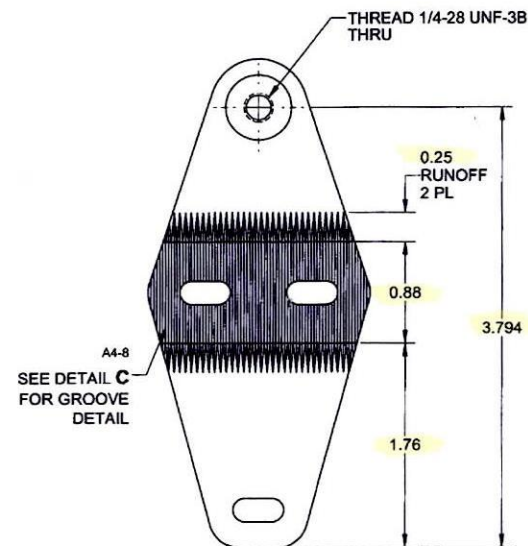
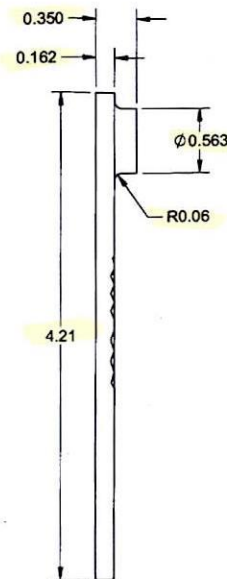
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TORQUE MS24694-S100 BOLT 50-70 in lbs (5.6-7.9 Nm)

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 6 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
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2016-07-26



NOTES:

NOTES:
1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643

PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-045" WITH 0.15 HIGH LETTERS TO A MAX DEPTH OF 0.010 IN AREA SHOWN.

7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4

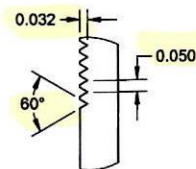
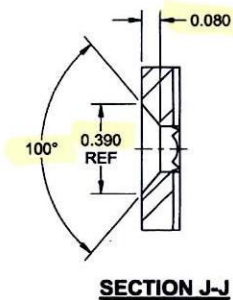
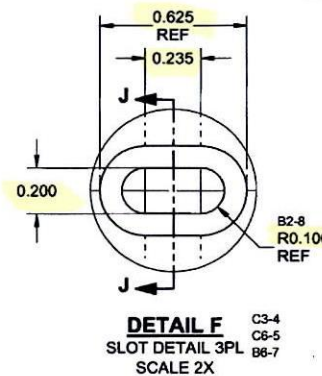
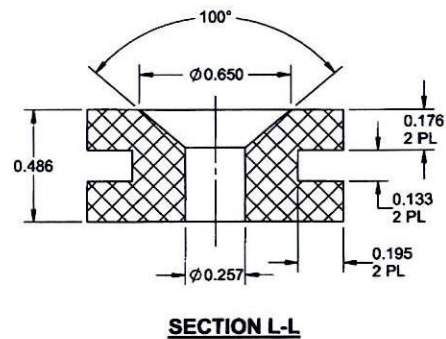
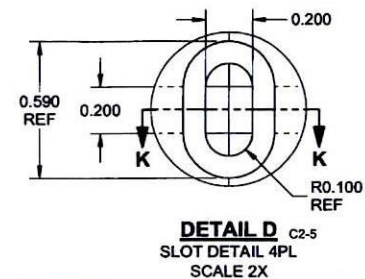
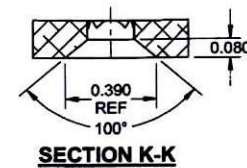
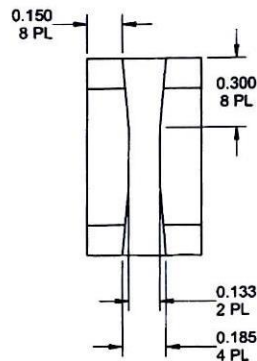
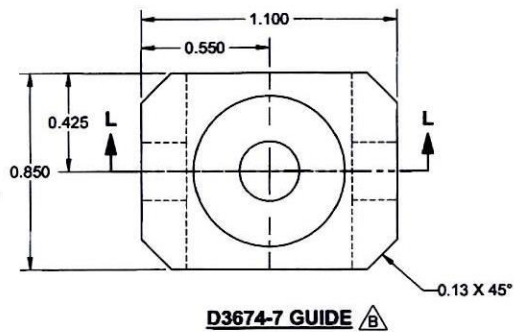
8) WEIGHT: 0.24 lbs

9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-5RevB.STP/.SLDPRT"

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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3674 TITLE ROLLER BRACKET ASSEMBLY COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	REV. B
DRAWN	AJS		SHEET 7 OF 8
CHECKED	MB		SCALE
MFG. APPR.	RQ		NTS
APPROVED	WM		
DE APPR.	DS		
DATE 16.06.01			



- NOTES:**
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.02 lbs

DETAIL C

RELEASED
2016-07-26

APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	MB
MFG. APPR.	RQ
APPROVED	WM
DE APPR.	DS
DATE	16.06.01

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3674	REV. B
TITLE ROLLER BRACKET ASSEMBLY	SCALE NTS
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DART AEROSPACE LTD	Work Order: 150040
Description: Roller bracket assembly	Part Number: D3674-5
Inspection Dwg: D3674 Rev: B	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.90	+/- .030	1.901	✓		Vern	GA-13
0.680	+/- .010	0.681	✓		"	"
0.340	+/- .005	0.340	✓		"	"
2.20	+/- .030	2.201	✓		H-6	31006
2.100	+/- .010	2.101	✓		"	"
0.220	+/- .010	0.220	✓		Vern	GA-13
15°	+/- 1/2°	15°	✓		Angle M.	CNC-17
R0.25	+/- .030	R0.250	✓		R-6	ref.
18°	+/- 1/2°	18°	✓		Angle M.	CNC-17
R0.42	+/- .030	R0.420	✓		R-6	ref.
0.350	+/- .010	0.350	✓		Vern	GA-13
0.162	+/- .010	0.162	✓		Mic	GA-03
φ0.563	+/- .010	φ0.564	✓		"	"
R0.06	+/- .030	R0.063	✓		R-6	ref.
4.21	+/- .030	4.210	✓		Vern	GA-13
0.25	+/- .030	0.250	✓		"	"
0.88	+/- .030	0.880	✓		"	"
1.76	+/- .030	1.770	✓		"	"
3.794	+/- .010	3.795	✓		"	"
0.032	+/- .010	0.031	✓		D-6	GA-08
60°	+/- 1/2°	60°	✓		Thread G.	ref.
0.050	+/- .010	0.050	✓		Vern	GA-13
0.625	+/- .010	0.627	✓		"	"
0.235	+/- .010	0.238	✓		"	"
0.200	+/- .010	0.200	✓		"	"
R0.100	+/- .010	R0.100	✓		R-6	ref.
100°	+/- 1/2°	100°	✓		Angle M.	CNC-17
0.390	+/- .010	0.388	✓		Vern	GA-13
0.080	+/- .010	0.079	✓		"	"

Measured by: B.F. DAS 08 9-89	Checked by: JK	QC Inspector:
Date: 16/09/06	Date: 16-9-10	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	